

Work Order ID 54448

December 9, 2009 11:15:20 AM



Page 1

Item ID: D2620

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube, 206 Skidtube

Start Date: 12/09/09 Start Qty: 10.00



Cust Item ID:

Required Date: 12/14/09 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2620

Rev B

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program
206.A : 1 and Folio Ft008: 2- Cut Fwd end of tube as per Dwg D2620

10 11/9/12/10

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

DP

9-12-10

(10)

120

Identify as per dwg & Stock Location: 46,

0.00



Packaging

Memo

0.00

Packaging

10 11/9/12/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54448

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Item ID: D2620

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube, 206 Skidtube

Start Date: 12/09/09 Start Qty: 10.00



Cust Item ID:

Required Date: 12/14/09 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/06 *[Signature]*
BS 10-1-09
(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 9, 2009 11:15:20 AM

Page 1

Work Order ID: 54448

Parent Item: D2620

Parent Item Name: Skidtube, 206 Skidtube

Comments:

Start Date: 12/09/09

Required Date: 12/14/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2600-1-160		Manufactured	No			100	Each	67.0000	10.0000			



Extrusion Round 3" 206



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

43969

67

67

DP 9-12-10
10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

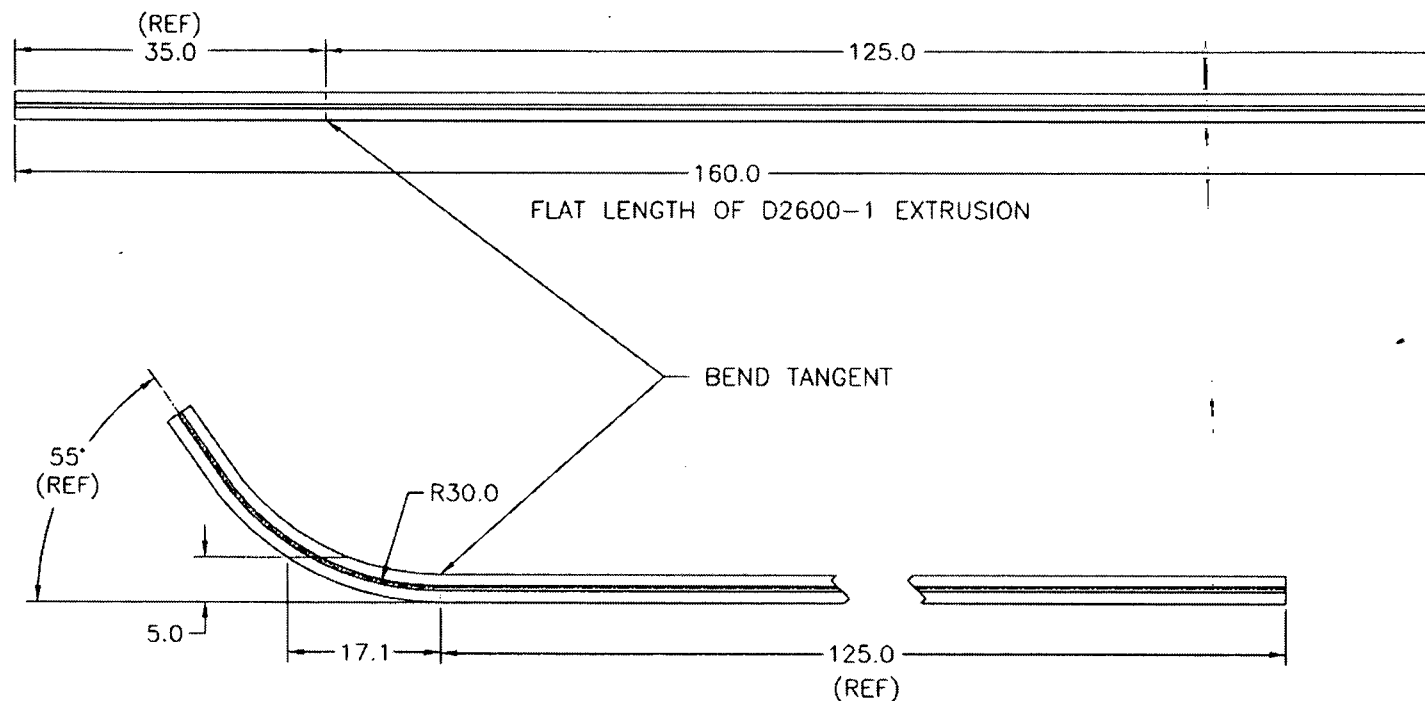
SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING

WB
54448

DART

QA COPY ISSUED



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND. TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND. TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

RELEASED
1997.09.15 DS

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. B
CHECKED	APPROVED	FAIRCHILD INTERNATIONAL AIRPORT, WA	SHEET 1 OF 1
DATE	TITLE	206 SKIDTUBE BENDING CONTROL	SCALE
99.09.10	NEW ISSUE		1:20
A	97.11.07	UPDATE FOR IN-HOUSE BENDING	
B	97.09.10		